

Date: Friday, 2/23/2007 8:30:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 30870		
Estimate Number	: 10195		
P.O. Number	: N/A	Part Number	: D21741
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D2174-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 26027	Material	: N/A
Written By	:	Due Date	: 3/24/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>JA 01.02.23</u>		
Comment	: Est C 04.06.09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 9.9162 sf(s) 4.4622
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Batch: M102942 x9 M103321 x11 M 070301

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2174
 Dwg Rev: E
 Prog Rev: E

M 070301

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 070301

(20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 070302

(21)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

SAD 07/03/05

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/30

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

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Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (21)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-R 07/03/07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

07/03/07 (21)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 07/03/29 21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(21) 07/03/30

Job Completion



U 07-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

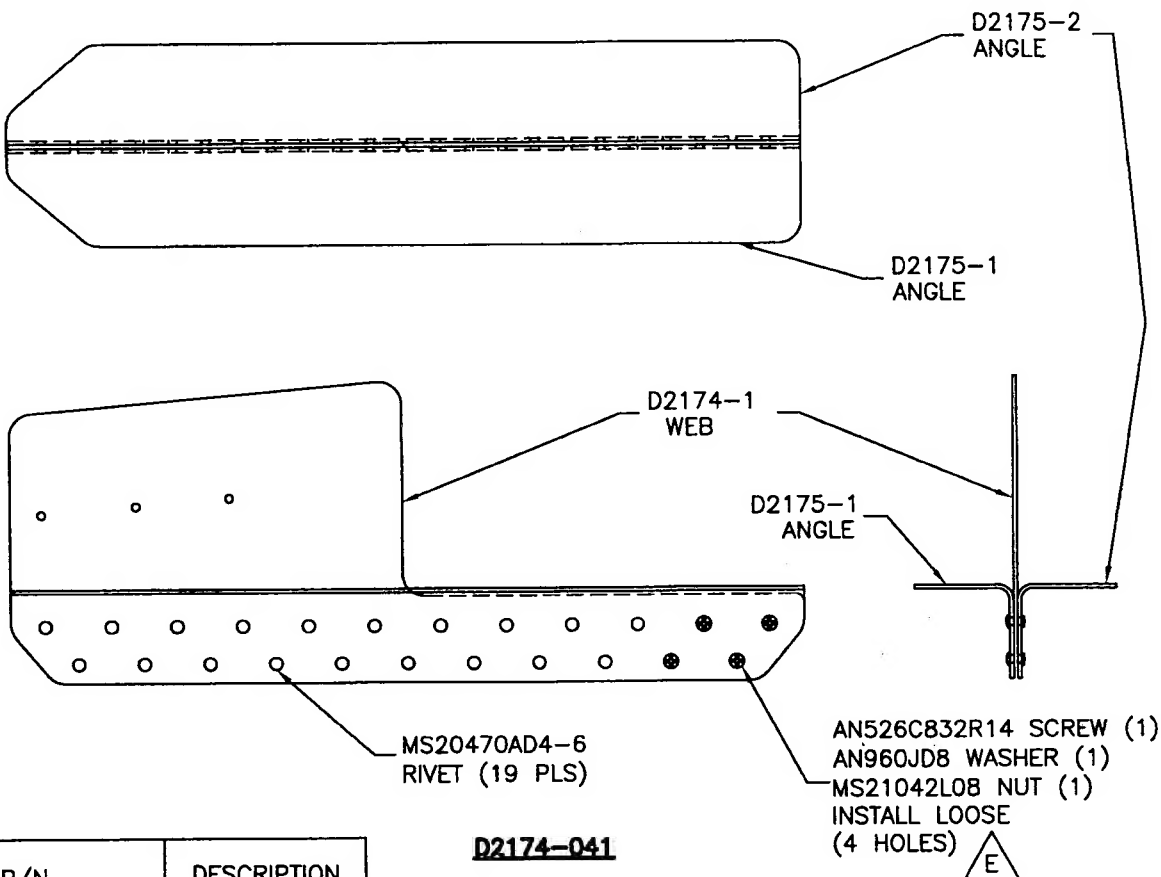
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CH	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
		SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30870

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

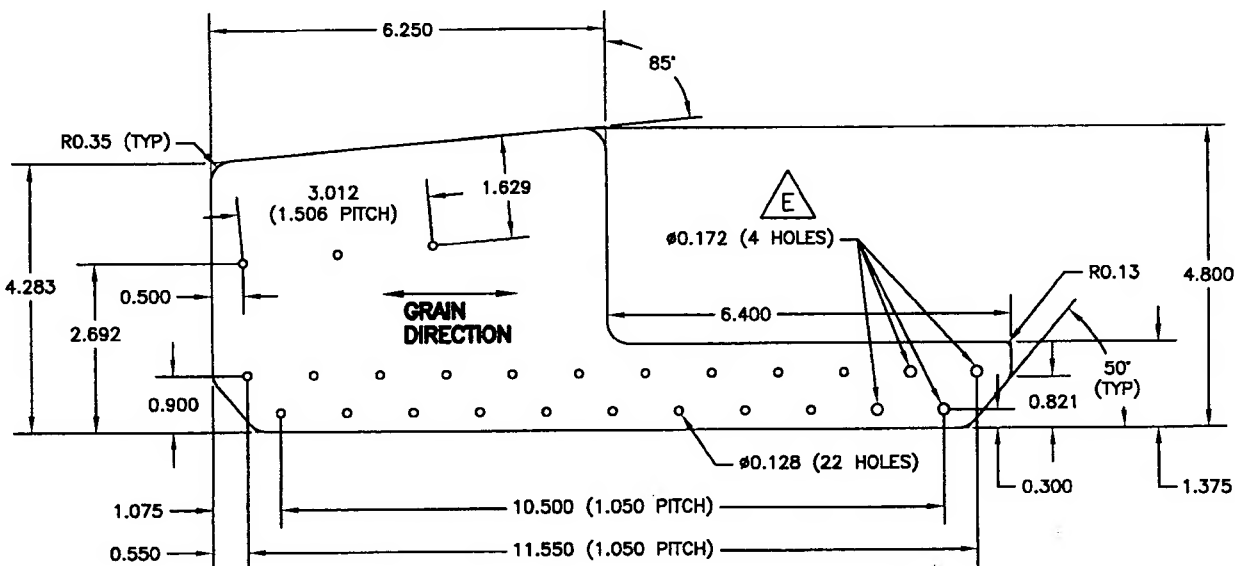
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

DART

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	REV. E
DATE	06.09.25	TITLE	WEB	SHEET 2 OF 2
		DRAWING NO.	D2174	SCALE
				1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

TOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30870

RELEASED
06.10.23

DART AEROSPACE LTD		Work Order:	30870
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174	Rev: DE	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.253	✓		vern	
6.400	+/-0.010	6.400	✓		vern	
4.800	+/-0.010	4.801	✓		vern	
1.375	+/-0.010	1.375	✓		vern	
1.050	+/-0.005	1.050	✓		vern	
Ø0.128	+0.005/-0.000	0.128	✓		vern	
12.650	+/-0.010	12.650	✓		measuring tape	
0.550	+/-0.010	0.548	✓		vern	
0.900	+/-0.010	0.905	✓		vern	
1.629	+/-0.010	1.633	✓		vern	
1.506	+/-0.005	1.507	✓		vern	
11.550	+/-0.005	11.550	✓		vern	
50°	+/-0.5°	50°	✓		Angle meter	
0.063 thick	+/-0.010	0.063	✓		vern	
Ø0.172	+0.005/-0.001	0.173	✓		vern	

Measured by: <i>MM</i>	Audited by: <i>AA</i>	Prototype Approval:	N/A
Date: 07/03/01	Date: 07/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	<i>AA</i>

AA